

Work Order ID 146212

Thursday, May 12, 2016 8:48:42 AM

146212

Page 1

Item ID: D117-837-111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: BK117 Basket Mounting Provisions

Start Date: 5/12/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/13/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: UMF Date: 16-5-13 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI9724	A
IIN-D117-837	B

MJ 16-05-12

100	Document Control	0.00
100	DOCUMENT CONTROL	
DC	Memo	0.00
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D117-837-111 CHG003	

1	DAS	MAY 13 2016
27		
9-09		

110	Pick Kit	0.00
110		
Packaging	Memo	0.00
Packaging		

1	DAS	MAY 12 2016
8		
9-09		
28		
9-09		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Work Order ID 146212

Thursday, May 12, 2016 8:48:42 AM

146212

Page 2

Item ID: D117-837-111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: BK117 Basket Mounting Provisions

Start Date: 5/12/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/13/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.03

Quality Control

1	DAS 27 9-89	MAY 13 2016
---	-------------------	-------------

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D117-837-111

Location: _____

PPP 144216

1	DAS 27 9-89	DAS 28 9-89	MAY 13 2016
---	-------------------	-------------------	-------------

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.10

Quality Control

MCS	MAY 13 2016
dm 16/05/13	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER :											

Picklist Print

Page 1

Thursday, May 12, 2016 8:48:41 AM

Work Order ID: 146212

146212

Parent Item: D117-837-111

D117-837-111

Parent Item Name: BK117 Basket Mounting Provisions

Start Date: 5/12/2016

Required Date: 5/13/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.28 NEW ISSUE DD VERF:JLM IPP
REV:B 13.06.21 IIN-D117-837 REV.A DD VERF:JFS IPP REV:C
14.07.25 ecn 14-571/ chg002 DD VERF:JLM IPP REV:D 15.05.27 add
DSI9727 as per ecn15-571 DD verf:jl

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-13A Bolt		Purchased	No				Each	501.0000	**	4		DAS 28 9-89	

Location Loc Qty Loc Code

FG 20
122808 20
GA 60
m134167 36
m134634 24
O003 200
m134754 200
over003 200
m134634 200
ST344 21
m134497 21

D5253-1

Manufactured No

D5253-1

Shim

D4893-1

Manufactured No

D4893-1

Hard Point Adapter, LH

Location Loc Qty Loc Code

ST536 2
122813 2

MAY 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
		OTHER : ☐																							

Picklist Print

Thursday, May 12, 2016 8:48:42 AM

Page 2

Work Order ID: 146212

146212

Parent Item: D117-837-111

D117-837-111

Parent Item Name: BK117 Basket Mounting Provisions

Start Date: 5/12/2016

Required Date: 5/13/2016

Start Qty: 1.00

Required Qty: 1.00

D4893-2 Manufactured No

Each 2.0000

D4893-2

Hard Point Adapter, RH

BAS
27
9-89

Location

Loc Qty

Loc Code

ST536

2

122815

2

Each

2.0000

**

2

BAS
28
9-89

D4894-1 Manufactured No

Each 2.0000

D4894-1

Fwd Beam

BAS
27
9-89

Location

Loc Qty

Loc Code

ST447

2

122818

2

Each

3.0000

**

1

BAS
28
9-89

D4894-3 Manufactured No

Each 3.0000

D4894-3

Aft Beam

BAS
27
9-89

Location

Loc Qty

Loc Code

ST447

3

121292

2

124098

1

Each

2.0000

**

1

BAS
28
9-89

D4895-045 Manufactured No

Each 2.0000

D4895-045

Fwd Outboard Beam Assembly

BAS
27
9-89

Location

Loc Qty

Loc Code

ST478

2

136931

2

**

1

BAS
28
9-89

MAY 12 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
										QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											

Picklist Print

Thursday, May 12, 2016 8:48:42 AM

Page 3

Work Order ID: 146212

146212

Parent Item: D117-837-111

D117-837-111

Parent Item Name: BK117 Basket Mounting Provisions

Start Date: 5/12/2016

Required Date: 5/13/2016

Start Qty: 1.00

Required Qty: 1.00

D4895-047

Manufactured No

Each 1.0000

D4895-047

Aft Outboard Beam Assembly

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST478

1

136930

1

Each 278.0000

**

DAS DAS
28 28
9-89 9-89

AN4-17A

Purchased No

AN4-17A

Bolt

Location

Loc Qty

Loc Code

over003

200

M134508

50

M134573

50

M134634

50

M134754

50

ST343

78

M133998

78

Each 55.0000

**

DAS
28
9-89

AN5-23A

Purchased No

AN5-23A

Bolt

Location

Loc Qty

Loc Code

ST337

55

M129630

5

M134634

50

Each 176.0000

**

DAS
28
9-89

MS20002C6

Purchased No

MS20002C6

WASHER

Location

Loc Qty

Loc Code

ST314

176

m132823

76

m134754

100

12

MAY 12 2016

Thursday, May 12, 2016 8:48:42 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER :									

Picklist Print

Thursday, May 12, 2016 8:48:42 AM

Page 4

Work Order ID: 146212

146212

Parent Item: D117-837-111

D117-837-111

Parent Item Name: BK117 Basket Mounting Provisions

Start Date: 5/12/2016

Required Date: 5/13/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

1,484.000

8

MS21042L4

Locknut

**

DAS

DAS

8

28

9-89

9-89

Location

Loc Qty

Loc Code

GA

195

m133769

195

OVER007

500

m134676

500

ST303

692

m134606

692

ST305

97

m130922

97

MS21042L5

Purchased

No

Each

461.0000

12

MS21042L5

Nut

**

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

101

m127813

101

OVER007

100

m134509

100

ST303

260

m134055

7

m134567

153

m134676

100

DAS
27
9-89

DAS
8
9-89

12

MAY 12 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER :			

Picklist Print

Page 5

Thursday, May 12, 2016 8:48:42 AM

Work Order ID: 146212

146212

Parent Item: D117-837-111

D117-837-111

Parent Item Name: BK117 Basket Mounting Provisions

Start Date: 5/12/2016

Required Date: 5/13/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

Each

275.0000

MS21042L6

Nut

**

12

DAS

28 9-8

DAS 6 9-89

Location

Loc Qty

Loc Code

ST303

275

m133938

6

m134055

19

m134509

100

m134567

50

m134676

100

12

MS21250-06022

Purchased

No

Each

56.0000

MS21250-06022

BOLT

**

12

88-6

82

SVG

DAS 6 9-89

Location

Loc Qty

Loc Code

OVER007

36

M134676

36

ST294

20

M129688

20

12

NAS1149D0416J

Purchased

No

Each

4,234.000

NAS1149D0416J

WASHER

**

16

DAS

28 9-89

DAS 6 9-89

Location

Loc Qty

Loc Code

GA

222

m131511

222

ST260a

1984

m131511

1984

ST264

2028

m131511

2028

16

MAY 17 2016

Thursday, May 12, 2016 8:48:42 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐											

Picklist Print

Thursday, May 12, 2016 8:48:42 AM

Page 6

Work Order ID: 146212

146212

Parent Item: D117-837-111

D117-837-111

Parent Item Name: BK117 Basket Mounting Provisions

Start Date: 5/12/2016

Required Date: 5/13/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0516J

Purchased

No

Each

135.0000

24

NAS1149D0516.I

**

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST264

135

M129706

135

24

NAS1149D0616J

Purchased

No

Each

182.0000

12

NAS1149D0616.I

**

WASHER

DAS
27
9-89

Location

Loc Qty

Loc Code

ST264

182

122815

182

12

DAS
28
9-89

DAS
28
9-89

MAY 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER :									

5.0 PARTS LIST

Qty -011	Qty -013	Qty -111	Part Number	Description
X			D117-837-011	HELI-UTILITY-BASKET, LH/RH
	X		D117-837-013	PROP ARM KIT
1		X	D117-837-111	BASKET PROVISION MOUNTING KIT
	1*		D2332-041	PROP ASSEMBLY (OPTIONAL)
	4*		D3953-9	WASHER
1			D4784-011	BASKET ASSEMBLY, HEAVY DUTY, LH/RH
1			D4794-043	STRUT ASSY
		2	D4893-1	HARDPOINT ADAPTER, LH
		2	D4893-2	HARDPOINT ADAPTER, RH
		1	D4894-1	FWD BEAM
		1	D4894-3	AFT BEAM
		1	D4895-045	FWD OUTBOARD BEAM ASSY
		1	D4895-047	AFT OUTBOARD BEAM ASSY
1			D4911-1	BRACKET
2			D4911-3	BRACKET
4			D5106-041	BRACKET ASSY
2			AN3-11A	BOLT
4			AN4-12A	BOLT
		4	AN4-17A	BOLT
		12	AN5-23A	BOLT
		12	MS20002C6	WASHER
2			MS21042-3	NUT
4		4	MS21042L4	NUT
		12	MS21042L5	NUT
		12	MS21042L6	NUT
4			MS21069L3	ANCHOR NUT
		12	MS21250-06022	BOLT
4			MS27039-1-08	SCREW
8			NAS1097AD3-4	RIVET
	3*		NAS1149C0463R	WASHER (or AN960C416)
8		8	NAS1149D0416J	WASHER (or AN960JD416L)
		24	NAS1149D0516J	WASHER (or AN960JD516L)
		12	NAS1149D0616J	WASHER (or AN960JD616L)
6			NAS1149F0332P	WASHER (or AN960-10L)

* D2332-041 PROP ASSEMBLY & HARDWARE (OPTIONAL) TO REPLACE D3969-3 GAS SPRING

• COPYRIGHT © 2013 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B

Date: 14.06.24

REFERENCE ONLY

CAS
97
9-99

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D117-837 REV. B AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D117-837 REV. 1
REF. TCCA STC: SH13-22
REF. FAA STC: SR03353NY

1.0 Purpose

Some customers have experienced problems with the alignment of the quick release pins after installing the D117-837-011 Basket kit after CHG 003. The purpose of this DSI is to provide instructions and parts to correct this mis-alignment. The DSI 9724-011 Shim Kit provides tapered shims that may be installed between the D5106-041 Bracket Assemblies and the bottom rib of the D4784-041 Basket Assembly.

2.0 Installing D5253-1 Shims

- 2.1 Unfasten D5106-041 Bracket Assy from D4784-041 Basket Assy.
- 2.2 Replace AN4-12A bolts with AN4-13A bolts and install D5253-1 shims as shown in Figure 1, using 2x NAS1149D0416J washers and 1 x MS21042L4 nut per shim. Pay attention to the orientation of the shim in relation with the basket center. Position the 4x D5253-1 Shims with the thicker side away from the center of the basket.
- 2.3 Fasten D5106-041 Bracket Assy to D4784-041 Basket Assy.
- 2.4 Continue with step 3.1.3 of IIN-D117-837 Rev. B.

3.0 Parts List

For D117-837-011 Heli-Utility-Baskets @ CHG 003 and later, the DSI 9724-011 Shim Kit is available from Dart. The parts in the DSI 9724-011 Shim Kit have been added to D117-837-011 Basket Kits @ CHG 006 and later.

Qty -011	Part Number	Description
X	DSI 9724-011	SHIM KIT
4	D5253-1	SHIM
4	AN4-13A	BOLT
4	MS21042L4	NUT
8	NAS1149D0416J	WASHER

4.0 Weight & Balance

This DSI has a negligible effect on Weight & Balance

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 15.05.11
CERT. NO.: SH13-22
ISSUE NO.: 1

A	NEW ISSUE	RF	15.05.11
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9724	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SHIM KIT	NTS
DATE	15.05.11	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	